Quality Control

November-11-1.				*1(191	195*						Page 1
Item ID: Revision ID: Item Name:	D3204-1			Accept		*N900	040	100)* s	Setup Star	1 /1	S1* S2*
Start Date: Required Date: Reference:	11/11/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item II Customer:	D:					(12
Approvals:	Process Pla	n: MC5	Date: /3-//-//	Tooling:		Da	te:		R	lun Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	_	Da	te:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hou	rs	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3204	Rev	A1										
*1\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	e Small	Hardinge CNC LATHE S Memo 1-Turn tube	SMALL as per Folio FA356 and Dw	0.00 0.00 g D32042-Deburr	FK	13/11/19.			22	Ø		
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	 1.					•		
1110 QC Quality Control		Memo		0.00	1-15	. 13/11/19			22_	Ø		
120 *120*		QC8- Inspect parts - seco	and check	0.00	7	12-11-20	3		22			
QC		Memo		0.00	-		•			<i>v</i> —		

DQA:			Date:			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~								TRACC
			5.			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Manle One		data ambi	AEROSPACE
QA Closed:			Date:				_			· · · · · · · · · · · · · · · · · · ·	vork Or	uer up	date only	
Work Orde	r:					DISPOSITION				AGAINST D	EPARTN	MENT,	PROCESS	
	-	· · · · · ·	···		_	Rework	ı		Skid-tube	Crosstube	7		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing	Re		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]		Supplier	1 🗆 1
										_				
Root					Desc	ription of work order update		nitial	Act	ion	Sigr	ո &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Da	ite	Verification	QC Inspector
Design							İ							
Doc/Data														
Equip/Tooling	_	•												
Handling/Pre														
Material														,
Operator														
Offset/Setup							l							
Process														
Supplier														
Training	Ш													
Transport														·
Unapproved				<u> </u>			<u> </u>							
						· · · · · · · · · · · · · · · · · · ·	FA	ULI CA	TEGORY					
Landi		1				General Bend		150150/1	Program	Г	المنادة	۰. ا	ensions	Pressure/Forced
	-	Bending Centre No	at Canaar	.+-:-	\vdash	BOM/Route	\vdash	Grain	riogrami	-			tolerance	Set-up
	-	ł	ot Concer	itric	-	-	\vdash	1	aro.	-	Part Ir		<u> </u>	Temperature/Cure
	-	Cracks Crimp/Ki	nk/Dinnla	AMouro	-	Broken/Damage/Defect Burrs	-	Hardwa	ire ion Incomplete/Ui	ngualified		ost/Mi		Weld
	_	Cuffs	uk) kibbie	, wave	\vdash	Contamination	-	1	tions Incomplete/U	_	Part N			Wrong Stock Pulled
}	-	Crushing			-	Countersink		4	gned/off center	Officient	Position		L_ Vrong	Tarrong Stock railed
		Heat Trea			 	Cut Too Short		Mislab	=	}	Power			Other
	<u> </u>	Inspectio		Tube	\vdash	Drawing	\vdash	Misrea		L		. 2000/		1 - 5.10.
	\vdash	Marks/Ch	-			Drill Holes	 	Off-set			-			,
	Н	Turning S				Finish		4	Calibration				······································	
		Wave/Tw				Fit/Function		4	Sequence					

Work Orde November-11-13				*109	2095*						Page :	2
Revision ID:	D3204-1 Tube			Accept	*N900	040	100)* s	etup Star	iVi	S1* S2*	
Start Date: Required Date: Reference:	11/11/13 11/25/13	Start Qty: 20.00 Req'd Qty: 20.00	*2(*2(· -	Cust Item I Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Stop	I/I	R1* R2*	
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Sto	ck Location: (())	Set Up/ Run Hours 160 — 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	1
120 Packaging Packaging		Memo ****STOC	K IN LARGE FAB**	0.00				79×			26 989 3-//-	20

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

*14**0***

Quality Control

M 13-11-20

AM 13/11/20

DQA:		Date:				TART							
					WORK ORDER NON-	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:		Date:				_				W	ork Order up	date only	
Work Order:				:	DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Order.					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part No	l_				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	·	,,			Use-as-is			noforming	Finishing		•	re/Packaging	Other
NCR No	٠.			,	Suspected Unapproved			Large Fab	Composite			Supplier	
						•						· 	
Root				Desc	ription of work order update	ı	nitial	Act	tion		Sign &		
Cause	Da	e Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design]					
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Material	_		1										
Operator	_]									
Offset/Setup	4					l							
Process	_					ĺ							
Supplier	4					ł							
Training	4							ļ _.					
Transport													
Unapproved			<u>l</u>	<u> </u>			=	<u> </u>			1	<u> </u>	
						FA	ULI CA	TEGORY					
Landing	_				General	$\overline{}$	11:-/) u a a u a u a		Г	Outside Dim	ansions F	Pressure/Forced
	Bend	_		-	Bend BOM/Route	-	Grain	Program			Over/Under	 	Set-up
! ⊢		e Not Conce	ntric	\vdash	-	-	Hardwa			┝	Part Incorre	 	Temperature/Cure
 	Crack	s o/Kink/Ripple			Broken/Damage/Defect Burrs	-	4	ire ion Incomplete/U	ngualified	\vdash	Part Lost/M	 	Weld
-	Cuffs	η κιτική κιφριέ	e, vvave	. -	Contamination	-	4	tions Incomplete/		\vdash	Part Moved	· -	Wrong Stock Pulled
 	Crusi	ina		-	Countersink	\vdash	-1	gned/off center	Oncical	一	Positioned V	_	
<u> </u>	—	mig Treat		-	Cut Too Short	\vdash	Mislab			\vdash	Power Loss/		Other
-	_	ction Strip ir	Tuhe		Drawing	\vdash	Misrea			<u> </u>	1. 0 2033/		1 - 1101
-	-	s/Chatter		 	Drill Holes		Off-set						
		ng Sequence	2		Finish	H	4	Calibration				• • • • • • • • • • • • • • • • • • •	
	-	:/Twist in Tu			Fit/Function	T	-	Sequence					

Picklist Print

November-11-13 1:50:02 PM

Work Order ID: 109095

109095

Parent Item:

D3204-1

D3204-1

Parent Item Name: Tube

Start Date: 11/11/13

Required Date: 11/25/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

B04.06.09Change Step 6; remove Steps 7 & 8KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.125		Purchased	No			100	f	25.0900	0.52	11			
N/6061T6	TO 750	M 105	•						**				

M6061T6T0 750W 125
6061-T6 RD Tube .750 x .125W

<u>Location</u>	Loc Qty	Loc Code		
MAT015	25.09			
★ J20918	25.09		12 1	F.K 13/11/19

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / UF				_	_	AEROSPACE
QA Closed:			Date:								Vorl	k Order up	date only		
Work Orde	r.					DISPOSITION		-		AGAINST D	EPA	ARTMENT	PROCESS		
	-					Rework	1		Skid-tube	Crosstube	7		Water Jet	\neg	Engineering
Part N	lo.					Scrap	1	ı	Machining	Small Fab	7	Pro	d. Eng. Coor.	┪	Quality
	•					Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo.			<u>_</u>	-	Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		nitial	Acti	ion	T	Sign &			
Cause		Date	Step	Qty		or non-conformance	1	ief Eng	Descri	iption		Date	Verification		QC Inspector
Design															
Doc/Data														1	
Equip/Tooling														-	
Handling/Pre							1								
Material															
Operator															
Offset/Setup											Ì				
Process											ŀ			ļ	
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							FA	ULI CA	TEGORY						
Landi		1			Г	General Bend	Г	ادمانه اد	Program	Г	\neg_{\circ}	outside Dim	onsions [\neg	Pressure/Forced
		Bending Centre No	at Cancar	ntrio	\vdash	BOM/Route		Grain	Togram	-	→	ver/Under	⊢	_	Set-up
		Cracks	or concer	ILLIC	-	Broken/Damage/Defect	\vdash	Hardwa	ro.	-	_	art Incorre	-	_	Temperature/Cure
	-	Crimp/Kir	nk/Dinnla	/\/\/ava	\vdash	Burrs	-	4	ion Incomplete/Un	ogualified L		art licorrec	 	_	Weld
		Cuffs	ik) kipbie	y wave	-	Contamination	-		tions Incomplete/U	· -	_	art Moved	33111g	\dashv	Wrong Stock Pulled
ļ	_	Crushing			-	Countersink	\vdash	4	gned/off center	F	—-	ositioned V	L. Vrong	لــــا	with a stock i alica
	\vdash	Heat Trea			<u> </u>	Cut Too Short	-	Mislabe	-			ower Loss/		\neg	Other
	\vdash	Inspectio		Tube		Drawing		Misrea		L	— '		υ- <u>L</u>		
	 	Marks/Ch				Drill Holes		Off-set			_				***************************************
	Г	Turning S				Finish		-	Calibration		_				
	Г	Wave/Tw	•			Fit/Function		-	Sequence						

DART AEROSPACE LTD	Work Order:	109095
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST										
		X First Arti	icle	Prot	otype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments			
Ø0.750	+/-0.010	125.	7		FK. GY	Ven	•			
Ø0.500	+/-0.010	, 500	7		h	t, "				
6.110	+/-0.010	6,106	\		i,	`				
							-			
	× A									
.,										
							J. 17			
Measured by:	134	Audited by:	67		Prototyn	e Approval:	N/A			
Date:	13/11/19.		13-11-	30)	Постур	Date:	N/A			
Rev Date	Change					Revised by	Approved			
A 05.02.17	New Issue	-				KJ/JLM KJ/JLM	1 A			
B 06.03.21	Dwg Rev updat	e				VANATIAI CAN	I \$/J//			

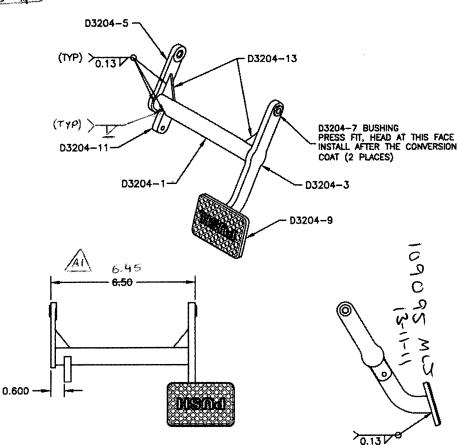
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DE	ign は	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CANADA				
СН	ECKED,	APPROVED	DRAWING NO.		REV.		1
	#		D3204	SHEET	1 OF	- ,	3
DA	E		TITLE		SC/	AL.	Ē
04	.01.27		RELEASE PEDAL ASSEMBLY		ħ	NT	5
Α		04.01.27	NEW ISSUE				

6.45 WAS 6.50



05.07.15

D3204-041 RELEASE PEDAL ASSEMBLY

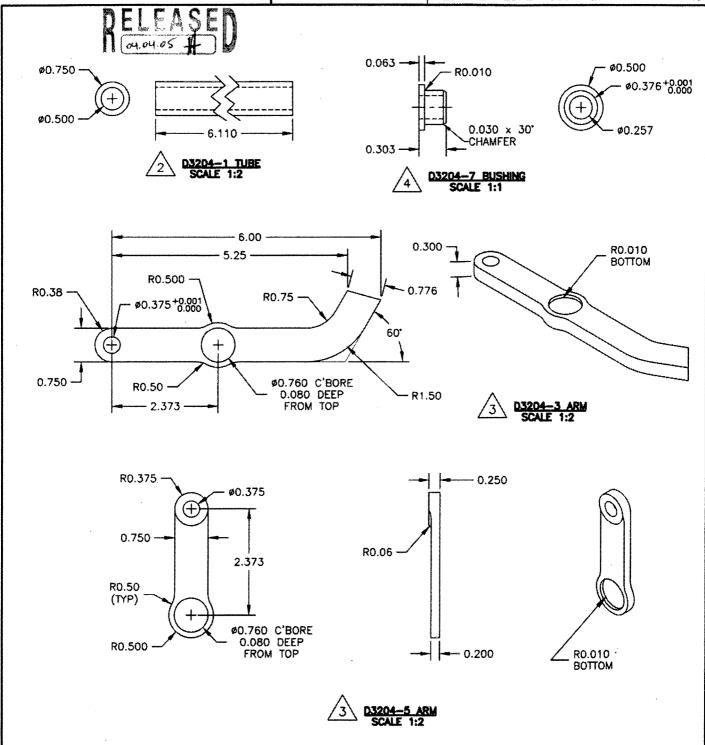
NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 4) MATERIAL: AISI 303 SS (M303K)
 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004
 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES





DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 2 OF 3
DATE	·····	TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS

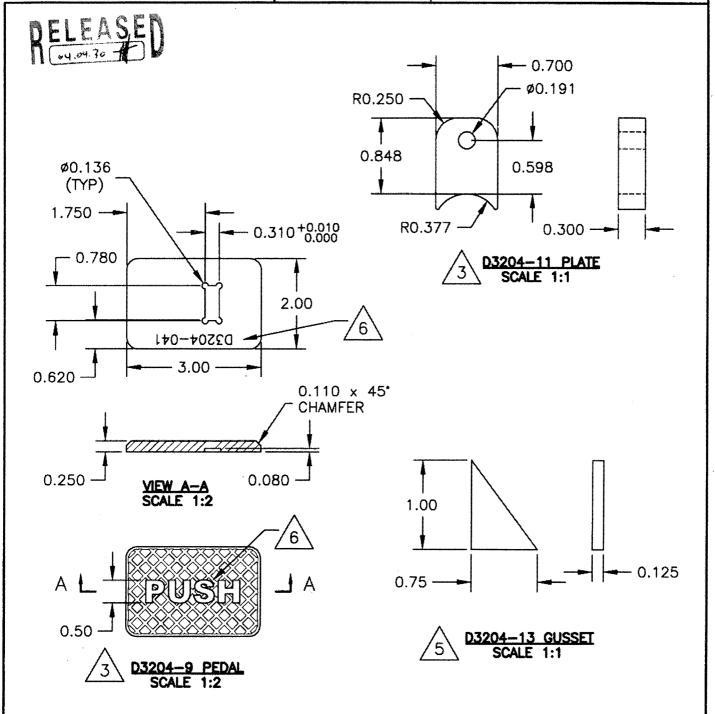


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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED,	APPROVED	DRAWING NO.	REV. A
4	-#	D3204	SHEET 3 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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